

Sup 24/07

Work Order ID 50891

July 23, 2009 2:55:47 PM

Page 1

Item ID: D2174-041

Accept

Revision ID: E

Item Name: Web, 205

Start Date: 7/24/09 Start Qty: 2.00

Required Date: 7/24/09 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2174

Rev E

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- Assemble as per Dwg D2174-041; 2- Identify as D2174-041

SB 09/07/24 (2) P

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> S07/07/24 (2) P

120

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

11:20

OVEN TEMPERATURE:

11:50 FINISH TIME:

300°

(12) SB 09/07/24

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Item ID: D2174-041

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Start Date: 7/24/09

Start Qty: 2.00

Required Date: 7/24/09

Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

⇒ Sorl 4/27

(42)

φ

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install nuts & bolts loosely as per Dwg D2274

EP09/07/27 (2)

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ Sorl 4/27

(42)

φ

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Start Date: 7/24/09 Start Qty: 2.00

Required Date: 7/24/09 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Packaging

Packaging

Identify as per dwg & Stock Location: *195*

0.00

Memo

0.00

9/17/09 *(Signature)*

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/07/2009 *(Signature)*

W 9.07.27

Picklist Print

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Page 1

Work Order ID: 50891

Parent Item: D2174-041RevE

Parent Item Name: Web, 205


Comments:

Start Date: 7/24/09

Required Date: 7/24/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2174-1RevE		Manufactured	No			100	Each	16.0000	2.0000			
												
Web												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

GA

16

50234

16

D2175-1RevE

Manufactured

No

100

Each

2.0000

2.0000



Angle LH



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

31691

2

D2175-2RevE

Manufactured

No

100

Each

1.0000

2.0000



Angle RH



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

48413

1

6 50230

2 8/10/09/24

2 8/10/09/24

1 8/10/09/24

Picklist Print

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Work Order ID: 50891

Parent Item: D2174-041RevE

Parent Item Name: Web, 205


Comments:

Start Date: 7/24/09

Required Date: 7/24/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L08		Purchased	No			100	Each	228.0000	8.0000			
												
Nut												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 228

110002 24

111889 30

112243 174

AN526C832R14 Purchased No 140 Each 1,013.000 8.0000



Screw

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 1013

104916 1013

Ep 09/07/27

8 ✓

Ep 09/07/27

8 ✓

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Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 50891

Parent Item: D2174-041RevE

Parent Item Name: Web, 205

Comments:

Start Date: 7/24/09

Required Date: 7/24/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD8		Purchased	No			140	Each	643.0000	8.0000			



Washer

Ep09/07/27

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	643
107091	9
108335	11
110382	48
110917	3
111578	572

MS20470AD4-6

Purchased

No

140

Each

1,317.000 38.0000



Rivet, Universal Head

Ep09/07/27

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	1317
109371	64
110915	1253

38

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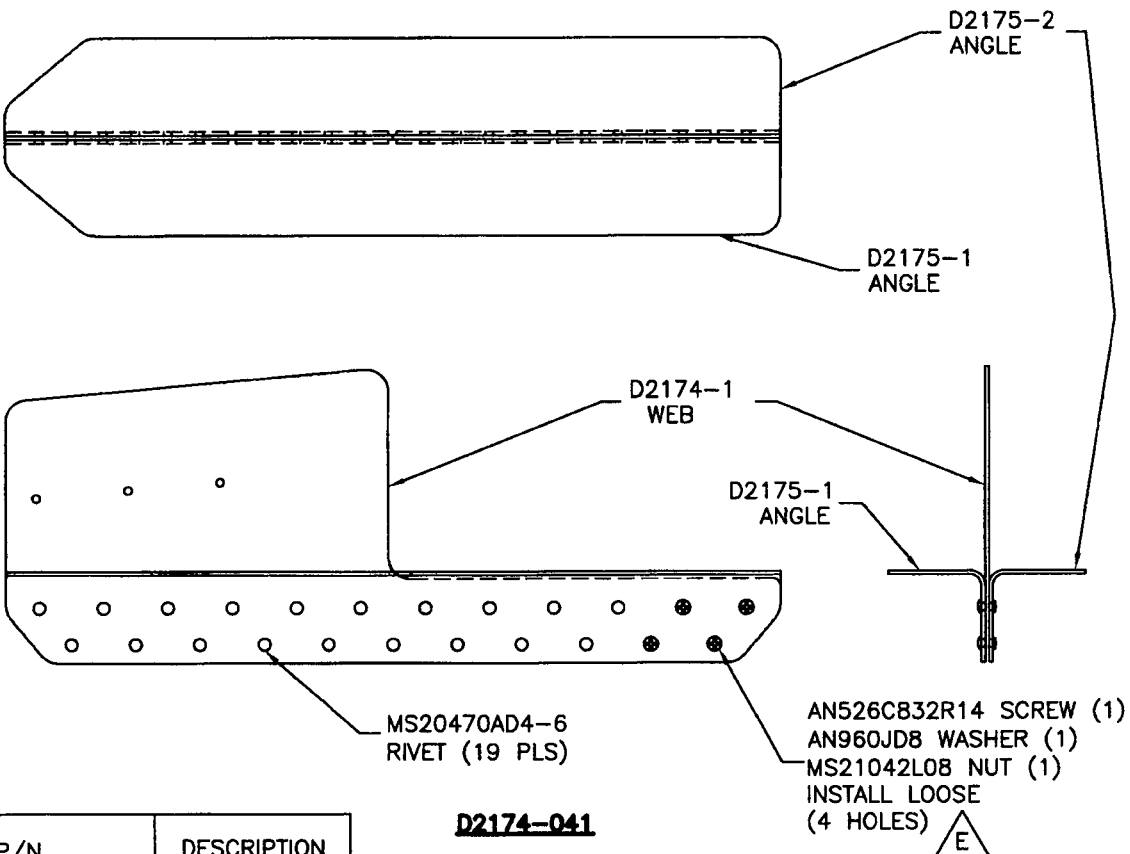
Shop Packet Print

Page 3

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. E
RF	CE	DRAWING NO.	D2174	SHEET 1 OF 2
CHECKED PH	APPROVED CE	DATE	06.09.25	SCALE 1:3
		TITLE	WEB ASSEMBLY	
A	95.10.25	NEW ISSUE		
B	96.01.18	RE-DRAWN		
C	00.09.11	UPDATE FINISH SPEC.		
D	04.06.03	RE-DESIGN		
E	06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE		

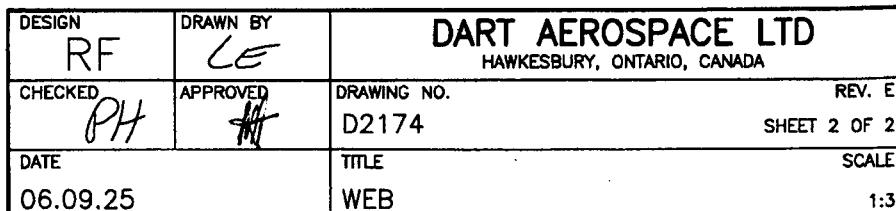
204801
204801



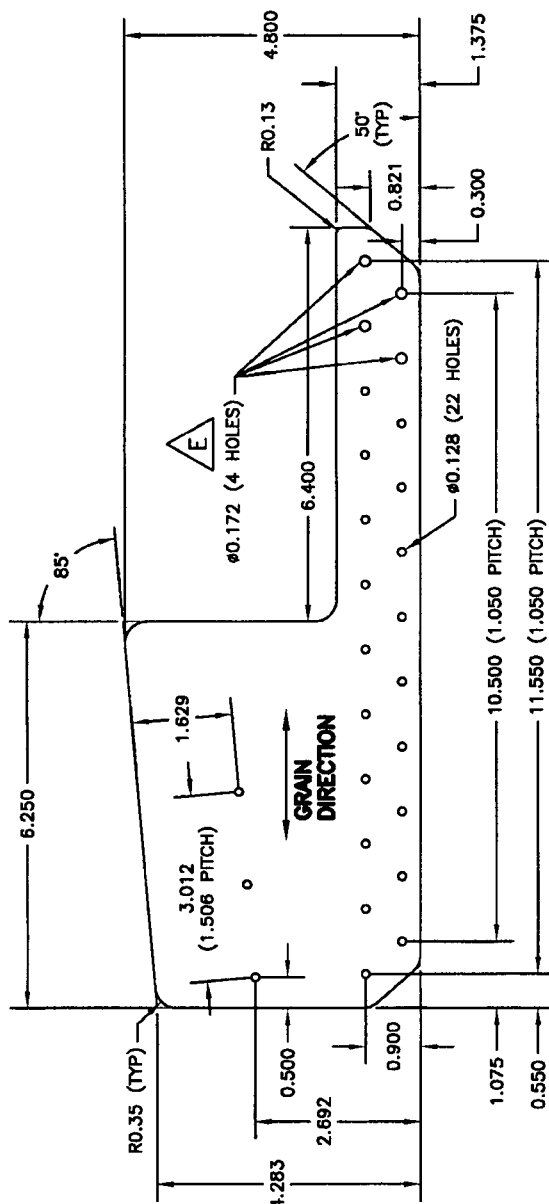
QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.



RELEASE
06 10 3



D2174-1

NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSION ARE IN INCHES

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